

Split

Order ID 79307-Z

79307

24-12 1:57:08 PM

Accept

N9000040100

Setup Start

NS1

Stop

NS2

ID:

me: Floor Window

ate: 24/01/2012 Start Qty: 8.00

ed Date: 07/02/2012 Req'd Qty: 8.00

ice:

als: Process Plan: M25

QC:

Date: 12/01/24

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

ice ID/
Center ID

Operation
Description

Revision Nbr

Revision Nbr

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

2

C

0.00

FLOW WATER JET

0.00

Memo

1-Cut blankas per Dwg D3212

Dwg Rev: C Prog Rev: C

2-Deburr if necessary

0.00

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

Machine as per Folio FA349 and Dwg D3212

SL 1/1/15

QC 2- Inspect parts off machine FA1/A1B

0.00

SL 1/1/15

Memo

0.00

20*

Control

Work Order ID 79307

January-24-12 1:57:08 PM

Item ID: D3212-1

Revision ID:

Item Name: Floor Window

Start Date: 24/01/2012 Start Qty: 8.00

Required Date: 07/02/2012 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Sequence ID/
Work Center ID

130

130

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Memo

Tooling:

SPC (Y/N):

Set Up/
Run Hours

0.00

0.00

0.00

0.00

0.00

0.00

140

140

Small Fab

Small Fab

Small Fab

Memo

1-Deburr if necessary 2-Install label as per Dwg D32123- polish abrasion scratches if necessary. 4-Wrap in plastic wrap after inspection

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Accept

79307

N900040100

Cust Item ID:

Customer:

Setup Start

NS1

Stop

NS2

Run Start

NR1

Stop

NR2

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Handwritten: 12/04/27

9X

Ø

Handwritten: 12/04/27

Handwritten: (QC) P

Work Order ID 79307

January-24-12 1:57:08 PM

79307

Item ID: D3212-1

Revision ID:

Item Name: Floor Window

Start Date: 24/01/2012 Start Qty: 8.00

Required Date: 07/02/2012 Req'd Qty: 8.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Sequence ID/
Work Center ID

160

160

Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location 210

Memo

Set Up/
Run Hours

0.00

0.00

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Date:

Date:

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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(911)

12/4/30

12/4/30

MF
12-04-30

DART AEROSPACE LTD		Work Order: 79307
Description: Floor Window		Part Number: D3212-1
Inspection Dwg: D3212	Rev: B	Page 1 of 1

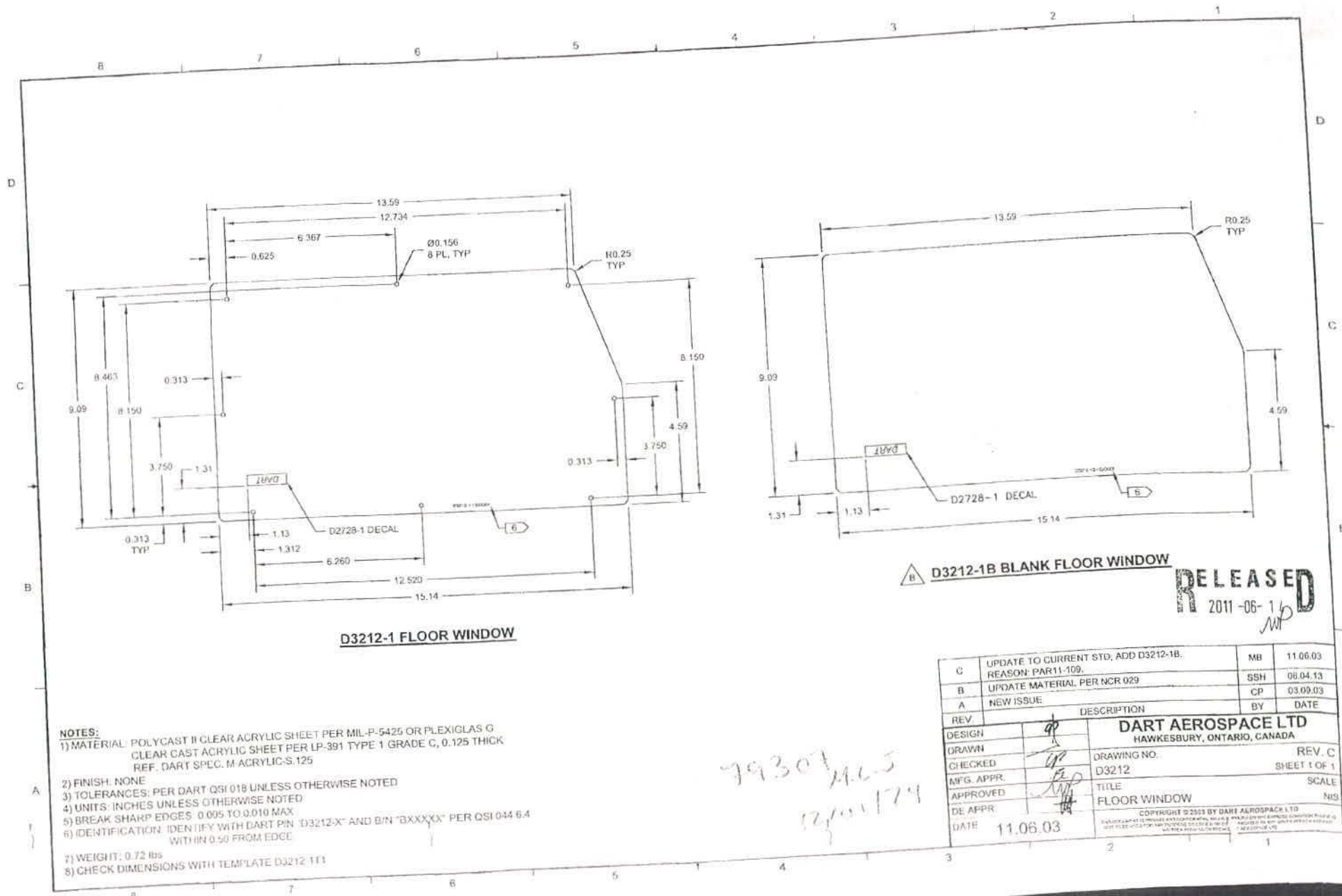
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.734	✓			
6.367	+/-0.005	6.367	✓			
0.625	+/-0.005	0.625	✓			
Ø0.156	+0.005/-0.001	0.156	✓			
R0.25	+/-0.030	0.25	✓			
8.150	+/-0.005	8.150	✓			
3.750	+/-0.005	3.750	✓			
0.313	+/-0.010	0.313	✓			
15.14	+/-0.030	15.14	✓			
12.520	+/-0.005	12.520	✓			
6.260	+/-0.005	6.260	✓			
1.312	+/-0.005	1.312	✓			
0.313	+/-0.010	0.313	✓			
3.750	+/-0.005	3.750	✓			
8.150	+/-0.005	8.150	✓			
8.462	+/-0.005	8.462	✓			
9.09	+/-0.030	9.09	✓			

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval: N/A
Date: 12/3/15	Date: 12/3/15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM [Signature]	[Signature]



D3212-1 FLOOR WINDOW

D3212-1B BLANK FLOOR WINDOW

RELEASED
2011-06-10

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M ACRYLIC-S.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3212-X" AND B/N "DXXXX" PER QSI 044 6.4 WITHIN 0.50 FROM EDGE
- 7) WEIGHT: 0.72 lbs
- 8) CHECK DIMENSIONS WITH TEMPLATE D3212 111

C	UPDATE TO CURRENT STD. ADD D3212-1B. REASON: PAR11-109.	MB	11.06.03
B	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
A	NEW ISSUE	CP	03.09.03
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3212
TITLE: FLOOR WINDOW
REV. C
SHEET 1 OF 1
SCALE: NIS

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